



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

647.7703
Job Sheet 186251



Part No: 647.7703

Job Qty: 20 ea

Part Name: Strut Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/13/18

Job Tracking No:

Due Date: 11/28/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV A2 IPP REV:A 15.01.07 NEW ISSUE DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	20 Ea		11/28/18	0.00	0.00	Start Up Large Fab-1		OK 18-11-16
110	Packaging	20 pcs		11/28/18	0.00	0.00	Packaging1		OK 18-11-16
120	Large Fab	20 pcs		11/28/18	0.00	7.91	Large Fab 4		OK 18-11-16
130	QC	20 pcs		11/28/18	0.00	0.00	QC9		FL
140	QC	20 pcs		11/28/18	0.00	0.00	QC5		FL
150	Outsource	20 pcs		11/28/18			GRO002-VC	10	OK 18-11-16
160	Packaging	20 pcs		11/28/18	0.00	0.00	Packaging2		NOV 22 2018
170	QC	20 pcs		11/28/18	0.00	0.00	QC5		NOV 22 2018
180	SprayPaint	20 pcs		11/28/18	0.00	1.14	Spray Paint		AR 18-11-28 9-89
190	QC	20 pcs		11/28/18	0.00	0.00	QC14		38
200	Packaging	20 pcs		11/28/18	0.00	0.00	Packaging3-1		NOV 29 2018
210	QC21-SA	20 Ea		11/28/18	0.00	0.00	QC21		NOV 29 2018

Part Op 120 - 1- ASSEMBLE AND WELD AS PER DWG ***IMPORTANT DIMENSION IS 8.35" ***

Descriptions: 150 - Issue P/O 507456 Group Altech CAD PLATE IAW QQ-P-416F CLASS I TYPE II note: cad plate should not be too thick around tread

180 - PRIOR TO PRIME MASK THREAD AND PRIME AS PER DWG 5074268

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
647.7712	Strut Tube	20 Ea (1 ea)	90-Start up Operation	5127899 (5)
647.7713	Strut Thread	20 Ea (1 ea)	90-Start up Operation	5114663 (15)
647.7714	Strut Tube	20 Ea (1 ea)	90-Start up Operation	5127899 (5) 5115328 (14) 5122182 (20)

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	647.7712	20	21	0
	647.7713	20	20	0
	647.7714	20	20	0

Part Specifications

Specifications could not be found.

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: Date:

Work Order update only ☐

Work Order: _____	DISPOSITION		AGAINST DEPARTMENT/PROCESS							
Part No. _____	Rework	☐	Skid-tube	☐	Cross tube	☐	Water Jet	☐	Engineering	☐
	Scrap	☐	Machining	☐	Small Fab	☐	Prod. Eng. Coord.	☐	Quality	☐
	Use-as-is	☐	Thermoforming	☐	Finishing	☐	Rec/Store/Packaging	☐	Other	☐
NCR No. _____	Suspected Unapproved	☐	Large Fab	☐	Composite	☐	Supplier	☐		☐

Date :	Step #:	QTY Effective :	MRB (QSI042) Approval
--------	---------	-----------------	-----------------------

1219 Albrecht Street Newbury, ON K6A 1K7 Canada TEL: 1-613-832-6200 Email: sales@darbee.com www.darbee.space.com 8424 6128424 Date: 11/16/18	Disposition	
	Completed By	
	Lead hand / Supervisor Approval Verification	
	QC / QA Coordinator Approval	

1210 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@darlaero.com
www.darlaerospace.com

Date: 11/16/18

DARI
AEROSPACE

Container No: S128424

Part: 647.7703

Job No: 186251

Serial No/Batch: S128424

Revision:

Inspector:
Exp Date:

Instructions:

Material	Use for Testing	Cuffs	Contamination	Out of Sequence	Part Lost/Missing
Internal Transport	Poor Information	Crushing	Countersink	Off-set	Drawing
Tribal Knowledge	Rushing	Heat Treat	Cut Too Short	Mislabeled	Finish
LOA	Product Improvement	Wave/Twist in Tube	Instructions Incomplete/Unclear	Fit/Function	Misread
Substation	Process Improvement	Marks/Chatter	Drill Holes	Misaligned/off center	Turning Sequence
Past Expiry Date	Manufacturing Process				
Misidentified	Past Due	OTHER :			



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO041756**

Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

PO No: PO041756
PO Date: 11/16/18
Due Date: 11/23/18
Purchase Order
Revision:
Revision Date:
Ship-To Contact: Tsimiklis, ChrisoulaPhone:

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground
Pymt Terms: Net 60
Freight Terms:
Special Comments: ** need back by Wednesday/Thursday, Please confirm ***

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	186053	647.7701	Strut Assembly Issue P/O : _____ Group Altech CAD PLATE IAW QQ-P- 416F CLASS I TYPE II note: cad plate should not be too thick around tread	Firmed	-	11/23/18	6 pcs	0 pcs	6 pcs	\$7.818181/pcs	\$46.91
2	186250	646.3912	Shim Issue P/O: _____ Cat Plating, CAD PLATE PER QQ-P- 416, TYPE II, CLASS 2, CL2	Firmed	-	11/23/18	40 pcs	0 pcs	40 pcs	\$16.568181/pcs	\$662.73
3	186251	647.7703	Strut Assembly Issue P/O : _____ Group Altech CAD PLATE IAW QQ-P- 416F CLASS I TYPE II note: cad plate should not be too thick around tread	Firmed	-	11/23/18	20 pcs	0 pcs	20 pcs	\$16.568181/pcs	\$331.36

Grand Total: \$1,041.00

24
22
20



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER PO041756

Order Notes

Procurement Quality Clauses

A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 11/19/18 1:15 PM dart.tsimiklis.chrisoula



Certificat de Conformité / Certificate of Compliance

(014543-1)

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9

Tel: 514-335-3666

Fax: 514-335-3868

www.groupaltech.com

Bon de Livraison / Packing Slip

014543- 1

Livré à / Ship to

DART AEROSPACE LTD

1270 ABERDEEN STREET

HAWKESBURY, ON, K6A1K7

CANADA

Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD

1270 ABERDEEN STREET

HAWKESBURY, ON, K6A1K7

CANADA

BUYER:

Date expédition Ship date		Créé Par Generated By		Transport / No de Compte Courrier / Acc. No.		Bon de commande Client Customer Purchase Order No.				
21-Nov-2018		Aman				041756 ✓				
#Ligne Line#	No. de Série / # Pièce Part Number /Line Item Details Job # / Ref #	Description pièce(s)		CATG. U/M	Comm. /Ordered	Exp/ Shipped	Quantités / Quantities Qté NC/ NC Qty		Qté Scrap/	À venir/ Back Order
1	647.7701 ✓ Rev.	647.7701 CAD PLATE IAW QQ-P-416F CLASS 1 TYPE 2 CAD PLATE SHOULD NOT BE TO THICK AROUND TREAD		CADMIUM CH	6	6 ✓	0	0	0	
2	646.3912 ✓ Rev.	646.3912 CAD YELLOW PLATE PER QQ-P-416 TYPE 2 CLASS 2		CADMIUM CH	40	40 ✓	0	0	0	
3	647.7703 ✓ Rev.	647.7703 01 -CAD YELLOW 0.0005 THICK CAD PLATE IAW QQ-P-416F CLASS I TYPEII CAD PLATE SHOULD NOT BE TOO THICK AROUND TREAD MATERIAL STEEL BAKE		CADMIUM CH	20	20 ✓	0	0	0	DAS 68 9-89

 DAS
68
9-89

Notes Additionnelles / Additional Notes

Epaisseur réelle
Actual Thickness
Inspecteur Qualité
Quality Inspector
Réçu par
Received By

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
 Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
 Our financial and legal responsibility will not be higher than the amount of invoice.

840
88
88.0